

Work Order ID 65735

Tuesday, January 25, 2011 10:14:57 AM



Page 1

Item ID: D2421

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw, 900

Start Date: 1/24/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 11-01-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2421

Rev F2

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per file D2421_BLANK

B11-1-27

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA124 and Dwg D2421
Identify as D2421
3-Deburr

*amf 1/16/2012**2 8*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

OK 11/02/02

2

0

OK

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

H.A 11/02/02

2

0

151

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

PP 6604f

C 11/2/3 (2)

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/03

MF
11-02-03

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Picklist Print

Tuesday, January 25, 2011 10:14:21 AM

Page 1

Work Order ID: 65735



Parent Item: D2421

Parent Item Name: Bearpaw, 900


Start Date: 1/24/2011

Required Date: 2/7/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	189.8794	4	8			



811-1-27

Location

Loc Qty

Loc Code

MAT

189.8794

114624

5.2734

115325

15.506

115955

38.8

116281

13

116554

117.3

116554

2

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DART AEROSPACE LTD		Work Order: 65735
Description: Bearpaw		Part Number: D2421
Inspection Dwg: D2421	Rev: F2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.20	+/-0.030	.193	—		Vern	ML-7
B	0.95	+/-0.030	.953	—		"	"
C	0.45	+/-0.010	.460	—		"	"
D	0.07 x 45°	+0.030/-0.010	.080 x 45°	—		"	"
E	0.69	+/-0.030	.701	—		"	"
F	0.38	+/-0.010	.384	—		Micr	118-126
G	0.44 - 0.47	+/-0.000	.465	—		Vern	ML-7
H	R0.25	+/-0.030	R.250	—		Rad-gage	RER
I	0.19 x 45°	+/-0.030	.180 x 45°	—		Vern	ML-7
J	23.00	+/-0.030	23.00	—		M-tape	ML-2
K	Ø0.260	+0.005/-0.000	Ø.265	—		Vern	ML-7
L	Ø0.93	+/-0.030	Ø.934	—		"	"
M	0.30	+/-0.030	.319	—		"	"
N	4.50	+/-0.030	4.500	—		M-tape	ML-2
O	9.50	+/-0.030	9.500	—		"	"
P	1.00	+/-0.030	1.000	—		Vern	ML-7
Q	14.750	+/-0.010	14.750	—		M-tape	ML-2
R	0.38	+/-0.030	.380	—		Vern	ML-7
S	4.54	+/-0.010	4.540	—		"	"
T	19.00	+/-0.030	19.000	—		M-tape	ML-2

Measured by: <i>Smk</i>	Audited by: <i>B.A</i>	Prototype Approval:	N/A
Date: 11/02/02	Date: 11/02/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	
B	04.11.29	Revised dimension M	KJ/JLM	

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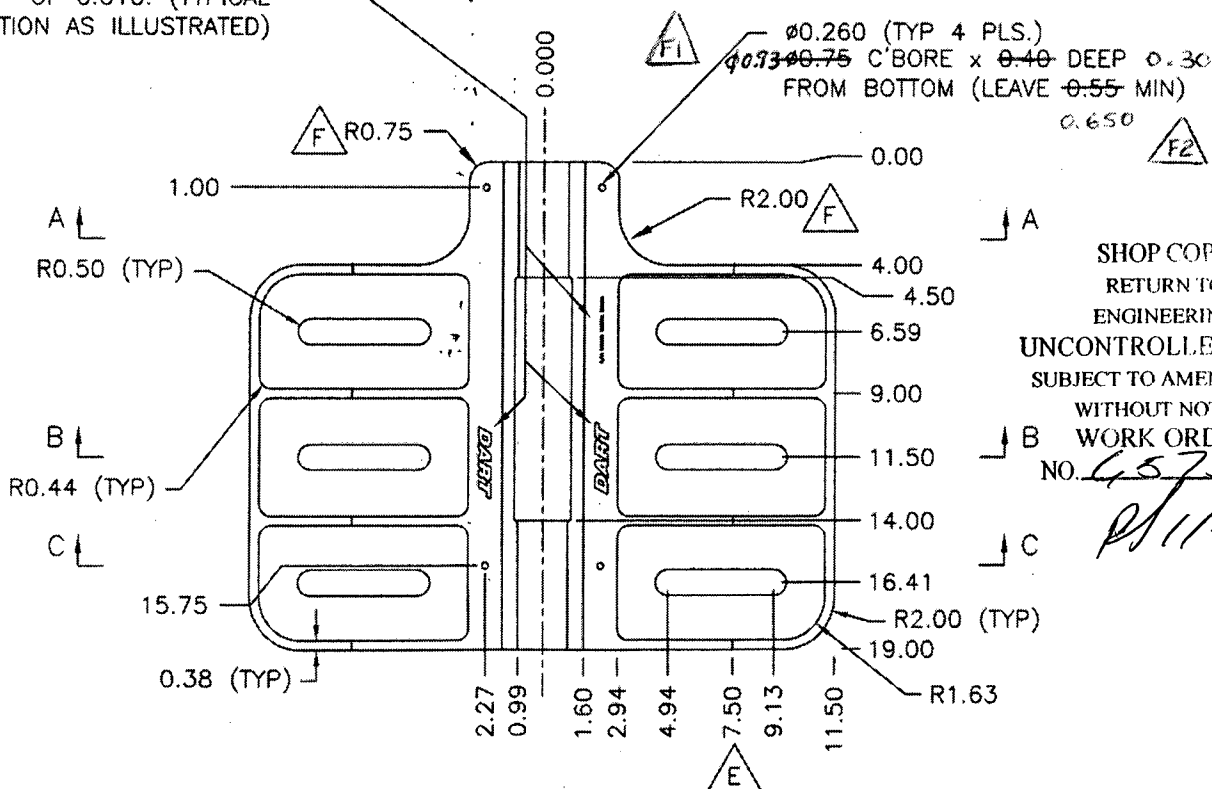
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED <i>[Signature]</i>	DRAWING NO. D2421	REV. F SHEET 1 OF 2
DATE 01.03.12		TITLE BEARPAW	SCALE 1:7
A	95.04.24	NEW ISSUE	
B	95.11.28	CHANGED NUMBER OF HOLES	
C	97.06.19	ADDED MATERIAL SPECIFICATION	
D	98.08.11	DIM MODIFICATIONS	
E	00.03.01	R1.77 WAS R2.66; ADD. R1.85 BORE RELIEF FOR CLAMPS; ADDED DEO 9155	
F	01.03.12	MODIFY FWD END	
F1	RF 03.01.13	Ø0.93 WAS Ø0.75; R0.19 WAS R0.38; 0.19 WAS 0.25	
F2	RF 04.11.03	0.30 WAS 0.40; 0.650 WAS 0.55	

RELEASED
01.03.14 *[Signature]*

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



SYMMETRIC ABOUT CENTER LINE

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689,
1.00" THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65735
PS/11-01-25

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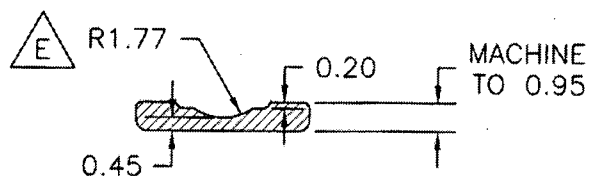
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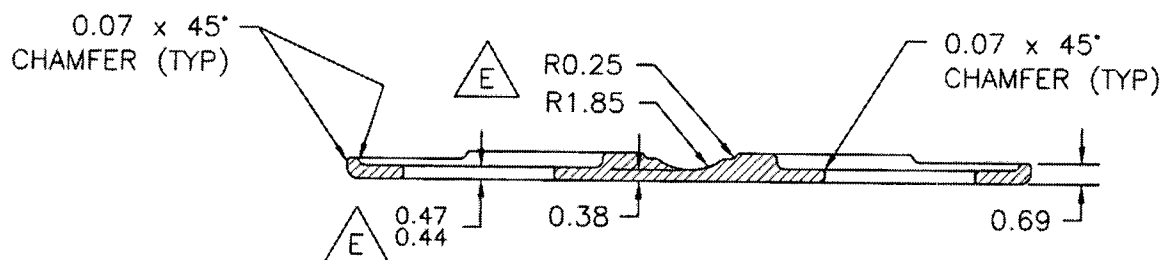
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED #	DRAWING NO. D2421	REV. F SHEET 2 OF 2
DATE 01.03.12	TITLE BEARPAW		SCALE 1:6

RELEASED
01.03.14 #

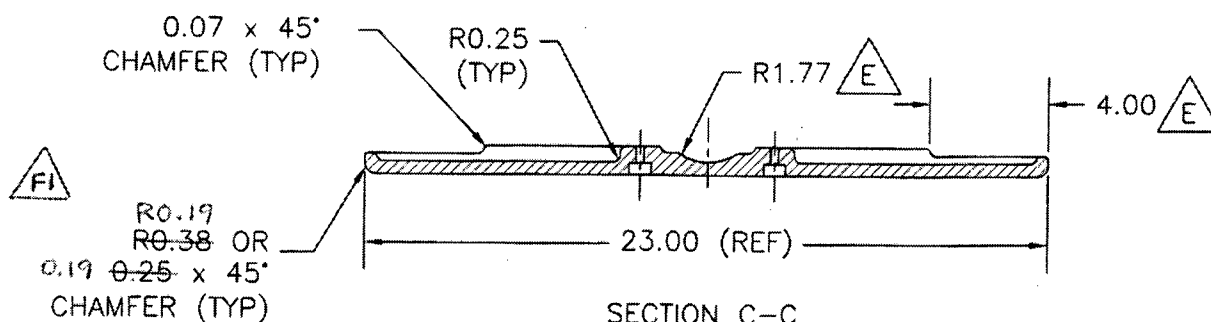


SECTION A-A

W1065735



SECTION B-B



SECTION C-C

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